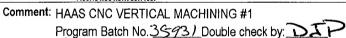
User:

Dart Aerospace Ltd. Wednesday, 11/21/2007 12:50:26 PM Kim Johnston **Process Sheet** : SADDLE FITTING, FWD (OUTBOARD/INBOARD) Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 35931 **Estimate Number** : 10530 Al4: : D2571 **Part Number** P.O. Number . D2571 REV E **Drawing Number** This Issue : 11/21/2007 : N/A Prsht Rev. Project Number : MACHINED PARTS First Issue **Drawing Revision** : '35915 Previous Run **Material** 12/23/2007 Each **Due Date** 12 Um: Written By Checked & Approved By Re-format; Change to Dwg Rev. D & Comment : Est: i **02**/10.02 incorporated D2572 KJ **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: 1.0 D6101007 7075-T7351 8.25X7.75X2.5

Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: B 31389

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1





1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

CONVENTIONAL MILLING

MILLING CONV



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

4.0

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



## **Dart Aerospace Ltd**

Dail At	OSpac	e Liu									
W/O:		WORK ORDER CHANGES									
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									-		
		Say.									
Part No	•	PAR #:	Fault Category:	NC	R: Yes	No DQ	A:	D Date:	sel01/17		
40						N/C Close					

NCR:		W	ORK OR	DER NON-CONFORMANCI	E (NCR)	8		
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Action Description Sign & Date		Section C	Chief Eng	QC Inspector	
		5						
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NOTE: Date & initial all entries

	Inesday, 11/21/2007 12:50:26 PM Johnston	Process Sheet
Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
	05004	D (N ) D0574
Job Number: Job Number:	35931	Part Number: D2571
our rained.		
Seq. #:	Machine Or Operation:	Description :
5.0		SECOND CHECK
	ent: SECOND CHECK	20/10/80
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
0		
Comme	ent: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	BR 08-01-11
7.0	POWDER COATING	POWDER COATING
		- M106379
Comme	nt: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as	
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		(2x)
Comme	nt: INSPECT POWDER COAT	8 11/1 08/01/14
9.0	PACKAGING 1	PÀCKAGING RESOURCE #17
Comme	nt: PACKAGING RESOURCE #1 Identify and Stock ,	10 211
	Location: ST 432	15 0/01/7 (XI)
10.0	QC21	FINAL INSPECTIONW/O RELEASE
0	TE CINAL INODESTICATION	
Comme	nt: FINAL INSPECTION/W/O RELEASE	N)08101/17
Job Completion		U 08,0617
	† 1887/198 OCEAN (1887 1888) 11878   1887   1887   1887   1887   1887   1887   1887   1887   1887   1887   1887	U Donvi
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Page 2

## **Dart Aerospace Ltd**

W/O:			WORK OF	RDER CHANG	ES			<u> </u>	
DATE	STEP	Р	ROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•						
		14			•				
Part No	\ <b>-</b>	PAR #:	Fault Category:		NCR: Ves	No DO	Δ.	Date:	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Verification	Annroval	Annroyal				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto				
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	3993
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

4				Re	corded Act	ual Dimens	ions		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
A	0.438	0.443	DT8682	441	,441	.441	-741		
В	1.745	1.755		1.750	1750	1.750	1751		
С	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	2750	1.750	1.750		
Е	7.990	8.010		8,000	8.000	8.000	8,000		
F	0.490	0.510		492	.495	1495	.491		
G	0.257	0.262	DT8683	259	258	.258	,258		
Н	0.375	0.380	DT8684	. 377	.377	.377	.37)		
Ι	0.490	0.510		.502	.895	1.505	.502		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.568	.560	568	.570		
L	1.174	1.184		1.180	1.180	6180	1.160		
М	1.490	1.500		1.500	1500	1,000	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
0	3.869	3.879		3.874	3.874	3.874	3.874		
Р	0.115	0.135		.125	.125	./25	125		
Q	0.115	0.135		./32	132	.138	./3/		
R	0.240	0.260		. 250	.250	.250	,200		
S	0.115	0.135	•	./32	134	.132	130		
T	0.178	0.198		.188	188	188	-188		
U	2.940	2.980		2-960	2.960	2-960	2-963		
V	0.230	0.250		,240	.240	.240	.239		
W	0.115	0.135		132	.130	1.130	,130		
X	0.308	0.313	-	310	.310	,310	-310		
Υ	0.760	0.765		.760	,760	760	,760		
Z	0.352	0.372		,3k2	,360	,360	,360		
AA	0.470	0.530		.500	,5-00	500	-500	'	
AB	0.615	0.635		.629	. 635	.630	1630		
AC	0.053	0.073		.063	.063	,063	.063		
AD	0.240	0.260		-250	.250	,250	250		
AE	1.375	1.395		1.386	1.386	1.386	1.386		
AF	0.115	0.135		-125	.125	,12(-	.125		
AG	0.240	0.280		,260	,260	.260	.260		
АН	0.240	0.260		-250	,250	. 250	.200		
ΑÏ	2.000	2.020		2.00	2.000	2-000	2.000		
AJ	0.023	0.043		,033	,033	,033	,033		••
	Acc	ept/Reje	ct						

Measured by: & Z	Audited by	SD	
Date: 08/01/03	Date:	10/80	/Oì

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.24	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	- 1
E	05.12.05	Added dimension AJ	KJ/JLM ox	Cill

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DART AEROSPACE LTD	Work Order:	35931
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Re	corded Act	ual Dimens	ions		
Dim	Min	Max	Go/No Go Gauge	51	6 2	71	4	Ву	Date
Α	0.438	0.443	DT8682	المالات	.440	. 440	.440		
В	1.745	1.755		1.750	1.750	1.750	1.750		
С	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8-004	8.004	8004		
F	0.490	0.510		.505	.505	.505	.505		
G	0.257	0.262	DT8683	.258	258	258	258		
Н	0.375	0.380	DT8684	.375	.375	.377	.377		
ì	0.490	0.510		-501	501	.403	, 503		
J	1.174	1.184	1 1 1 1 1 1	1.180	1180	1-180	1.180		
K	0.558	0.578		,568	569	.570	.570		
L	1.174	1.184		1.180	1.880	1.180	1.180		
М	1.490	1.500		1.500	1500	1.500	1,500	121	
N	2.495	2.505	- H	2.500	2.500	2500	2500		
0	3.869	3.879		3.874	3.874	3.874	3.874		
Р	0.115	0.135		.120	.120	.125	1/26		
Q	0.115	0.135		135	.735	.135	.135		
R	0.240	0.260		.250	,250	.250	.250		
S	0.115	0.135		.126	./30	1130	1130		
T	0.178	0.198		.188	.188	184	.188		
Ū	2.940	2.980	<del></del>	2.963	2.963	2.963	2.963		
V	0.230	0.250		,240	,210	. 740	1740		
W	0.115	0.135		120	-129	.170	.130		
Χ	0.308	0.313		.310	.310	.310	1310		
Υ	0.760	0.765		.764	. 764	.764	.764		
Z	0.352	0.372		360	. 360	. 360	. 360		
AA	0.470	0.530		.500	.500	,500	,500		
AB	0.615	0.635		. 635	635	.635	.635		
AC	0.053	0.073		.053	.063	.063	.063		
AD	0.240	0.260		.250	,250	,250	,250		
AE	1.375	1.395		1.385	1.385	1.388	1.388		
AF	0.115	0.135		. 125	-125	.125	.125		
AG	0.240	0.280		,260	,260	,260	,260		
AH	0.240	0.260		,250	,250	. 250	.750		
Al	2.000	2.020	······································	2.000	Z-000	2.000	7000		
AJ	0.023	0.043		. 533	1033	, 63>	, 633		
		ept/Reje	ct		100	<del>                                     </del>	1 1 1 2 3 - 1		

Measured by:	Audited by SD
Date: 07/01/04	Date: 0 8/01/0 つ

Date	Change	Revised by	Approved
	New Issue	RF	
02.09.24	Re-format; Added Rev. D	KJ	
02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
05.05.05	Added dimension Al	KJ/RF	1
05.12.05	Added dimension AJ	KJ/JLM A	all
	02.09.24 02.10.11 05.05.05	New Issue  02.09.24 Re-format; Added Rev. D  02.10.11 Re-format; Added DT8682, DT8683, DT8684  05.05.05 Added dimension Al	New Issue         RF           02.09.24         Re-format; Added Rev. D         KJ           02.10.11         Re-format; Added DT8682, DT8683, DT8684         KJ           05.05.05         Added dimension Al         KJ/RF

DART AEROSPACE LTD	Work Order:	35931
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 9	2	3	4	Ву	Date
A	0.438	0.443	DT8682	.440	. 440	.440	.440		
В	1.745	1.755		1.750	1.750	1.750	1.750		
С	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.007	8.003		
F	0.490	0.510		.505	.505	.505	. 505		
G	0.257	0.262	DT8683	. 259	. 254	. 259	. 254		
Н	0.375	0.380	DT8684	.376	-376	. 376	.376		
	0.490	0.510		.502	.502	-502	- 502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		. 568	.568	. 568	. 568		
L	1.174	1.184		1.179	1.170	1.179	1.179		
М	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		7.500	7.500	7.500	7.500		
0	3.869	3.879		3.874	3.874	3.874	3-874		
Р	0.115	0.135		.126	126	.126	-126		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		. 750	. 250	. 250	. 250		
S	0.115	0.135		.127	.127	.127	.127		
T	0.178	0.198		.188	. 188	. 188	.188		
U	2.940	2.980		7.964	2.964	7.964	2.964		
V	0.230	0.250		.740	.240	.240	.740		
W	0.115	0.135		€.126	.126	.126	.126		
Х	0.308	0.313	4	,310	,310	, 310	.310		
Υ	0.760	0.765		. 760	1760	.760	.760		
Ż	0.352	0.372		. 360	,360	, 360	.360		
AA	0.470	0.530		.500	.500	. 500	. 500		
AB	0.615	0.635		. 630	. 630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260	-	. 255	. 255	. 255	. 255		
AE	1.375	1.395		1.387	1.387	1.387	1.387		
AF	0.115	0.135		.175	.125	.125	.125		
AG	0.240	0.280		.750	.750	. 750	.250		
AH	0.240	0.260		. 250	.250		.250		······································
ΑI	2.000	2.020		2.000		2.600	2.000		
ĀJ	0.023	0.043		.033	. 633	.633	.033		<u>.</u>
	Acc	ept/Reje	ct						

Measured by:	36	Audited by	27	^
Date:	08.01.05	Date:	08/01	/09

Rev	Date	Change	Revised by	Approved	
A		New Issue	RF		
В	02.09.24	Re-format; Added Rev. D	KJ		
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ		
D	05.05.05	Added dimension Al	KJ/RF	1	
E	05.12.05	Added dimension AJ	KJ/JLM a	all	

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